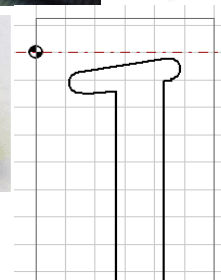
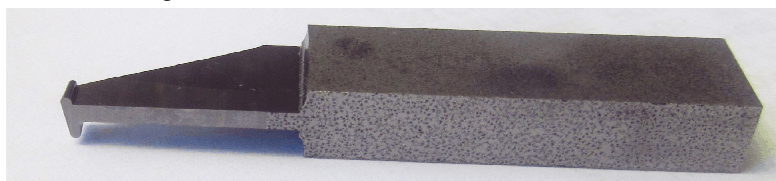
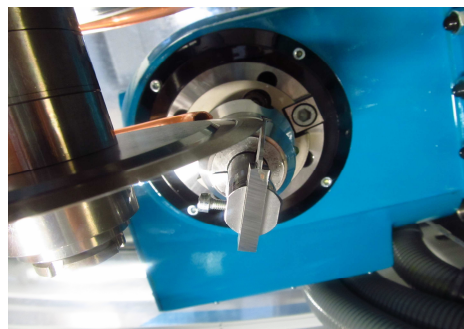


ID Turning Insert 17x3.8 R0.4

A08-010

This ID-Turning insert is ground from a solid rectangular blank. In order to be able to grind the complete profile in one setup, a rotation of nearly 270° is required, guaranteed with a slender clamping system. The individually definable grinding positions of the 14EE1 wheel along the profile is fully controlled through the dxqProcessmaker of Quinto5. Single pregrinding plunge-operations are also available. Finally a polishing operation resharpens the cutting face.



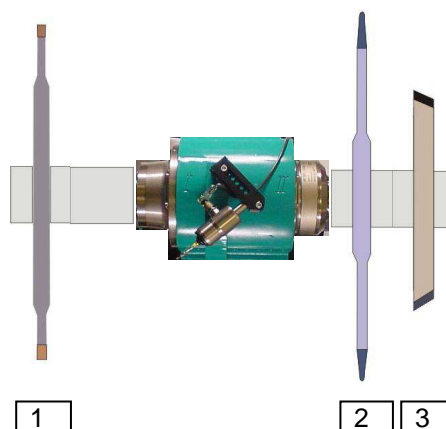
1. Cycletime for Production

Workpiece:	Blank 6x10x30 mm, Profile 17x3.8 R0.4 W10° Material CARBIDE							
Operations								
Feed [mm/Min]	2000	15	15	15	20	50	60	50
Power [kW]		1	1	1	4	3	2	2
Cutting speed [m/s]		22	22	22	22	22	22	22
Used wheels								
Grinding time [s]	15	92	92	92	296	121	102	39
Total cycle time	14 Min 9							

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14A1 Ø200 D64
2	14EE1 Ø200 D64
3	1V1 Ø100 D25



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG Coolant: Synthetic Oil, pressure 6 bar
Control: Fanuc 31iA5 Software: Quinto 5
Accessories:
Responsible engineer: OP, 2.5.12

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